



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D2586

Job Sheet R207049-A



Part No: D2586

Job Qty: 10 pcs

Part Name: Door Latch



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/15/20

Job Tracking No: ECN2020-513

Due Date: 5/18/20

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG D2586 REV F IPP E 02.01.31 Added Inspect level 21 NG/IPP RevF: add not to keep key with latch DD
10.02.10 verified by:JLM//IPP Rev. G 2020.02.18 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
124	QC 8	10 pcs	5/16/20	5/16/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - 2 - B4B	10 pcs	5/18/20	5/18/20	0.00	0.64	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		

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140 QC 5	10 pcs	5/18/20	0.00 0.00	Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
150 Packaging 3-1 - Stock - B4B 10 pcs		5/18/20	0.00 0.00	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

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				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - SA	10 pcs	5/18/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
				Broussard	9-88
Part Op 124 - (QC8- Inspect parts - second check) Descriptions: 130 - (Small Fab) 1-Toutch up ALODINE and paint as per drawing note 2. 2-Reassemble latch arm to latch body. 3-Assemble Lock Nut to Hinge. Leave Latch Unlocked. 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Identify as per dwg & Stock Location: _____) ***Ensure key is bag with latch*** 160 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D3015-7	Lock Nut N/A	10 pcs (1 ea)	130-Small Fab - 2 - B4B		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
130-Small Fab - 2 - B4B	D3015-7 N/A	10	161	0	
Part Specifications					
Specifications could not be found.					

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D2586

Job Sheet R207049



Part No: D2586

Part Name: Door Latch



Part Weight: 0 lbs

Job Created: 2/18/20

Due Date: 2/21/20

Type: Rework

Job Qty: 77 pcs

Status: New

Priority: Medium

Job Tracking No: ECN2020-513

Created By: Linda Lacelle

Description:

Note: DWG D2586 REV F IPP E 02.01.31 Added inspect level 21 NG/IPP RevF: add not to keep key with latch DD 10.02.10 verified by:JLM/IPP Rev. G 2020.02.18 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
122	Rework - 1 - Startup	77 pcs	2/21/20	2/21/20	0.50	19.25	Conventional Lathe - 1		JL 20-2-19
							Conventional Lathe - 2		
123	QC 2	77 pcs	2/21/20	2/21/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		JL
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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Container No: S270341

Part: D2586

Job No: R207049

Serial No/Batch: S270341

Revision: Rev F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/14/20

124 QC 8	77 pcs	2/21/20	0.00	0.00	QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	mmc Dr/for/14
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130 Small Fab - 2 - B4B	77 pcs	2/21/20	0.00	4.95	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
140 QC 5	77 pcs	2/21/20	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	

				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150	Packaging 3-1 - Stock - B4B	77 pcs	2/21/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
160	QC 21 - SA	77 pcs	2/21/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
					Broussard
Part Op 122 - 1-Remove latch lever. 2-Machine latch body as per drawing detail F-F. 3-Debur 4-Keep latch lever and body Descriptions: together as a pair for reassembly at sequence 130. 123 - (QC2- Inspect parts off machine FAI/FAIB) 124 - (QC8- Inspect parts - second check) 130 - (Small Fab) 1-Touch up ALODINE and paint as per drawing note 2. 2-Reassemble latch arm to latch body. 3-Assemble Lock Nut to Hinge. Leave Latch Unlocked. 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Identify as per dwg & Stock Location: _____) ***Ensure key is bag with latch*** 160 - (QC21- Final Inspection - Work Order Release)					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2586	Door Latch	77 pcs (1 ea)	130-Small Fab - 2 - B4B	
D3015-7	Lock Nut	77 pcs (1 ea)	130-Small Fab - 2 - B4B	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
130-Small Fab - 2 - B4B	D2586	77	50	0
	D3015-7	77	121	0
Part Specifications				
Specifications could not be found.				

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Part Number	Operation Number	Operation	Container No	Job	Master Unit Number	Quantity	Weight	Serial No/Batch	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No	Expiration Date
Part Number: D2586 Revision: Door Latch																	
D2586	110	Packaging 2-1 - Receive - B4B	S254088	206135		50 pcs	0	S254088	Packaging 2 - 5 - B4B		WIP	2/7/2020					
Operation Totals:			1			50	0										
D2586	160	QC 21 - SA															
			F152211			2 pcs	0	152211	Broussard		Quarantine	10/10/2017	Will need to be re-worked/ returned as part does not function with current dimensions. VM				
			S223350	201623		23 pcs	0	S223350	Quarantine Bin		Quarantine	10/17/2019	Will need to be re-worked/ returned as part does not function with current dimensions				
			S233490	203068		4 pcs	0	S233490	Quarantine Bin		Quarantine	11/20/2019	Will need to be re-worked/ returned as part does not function with current dimensions. VM				
			S245345	204564		50 pcs	0	S245345	Quarantine Bin		Quarantine	1/7/2020	Will need to be re-worked/ returned as part does not function with current dimensions. VM				
Operation Totals:			4			79	0										
Part Totals:			5			129	0										
Totals:			5			129	0										

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Entered: JR Date: Tue 12/2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8128

Route update only ☐

Job: <u>R207049-A</u> Part No. <u>D2586</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐				Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>20-4-14</u>		Sequence #: <u>122</u>		QTY Affected: <u>+ 10</u>				MRB (QS1042) DAS 9 9-89 <u>20-4-14</u>					
Description Work Order Deviation				Disposition				Completed By					
- 1 part is scrap - roll pin was crushed during disassembly - unable to use				- SCRAP				<u>JL</u> <u>20-4-14</u>					
								Lead hand / Supervisor					
								<u>h</u> <u>20-04-14</u>					
								QC / QA Coordinator					
								DAS 9 9-89 <u>20-4-14</u>					
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread									
				Other/Details:									